

Work Order ID 144312 -2

April 12, 2016 11:41:23 AM

144312

Page 1

Item ID: D3859-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Assembly

Stop

NS2

Start Date: 4/18/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: SLA

Date: 20160412

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

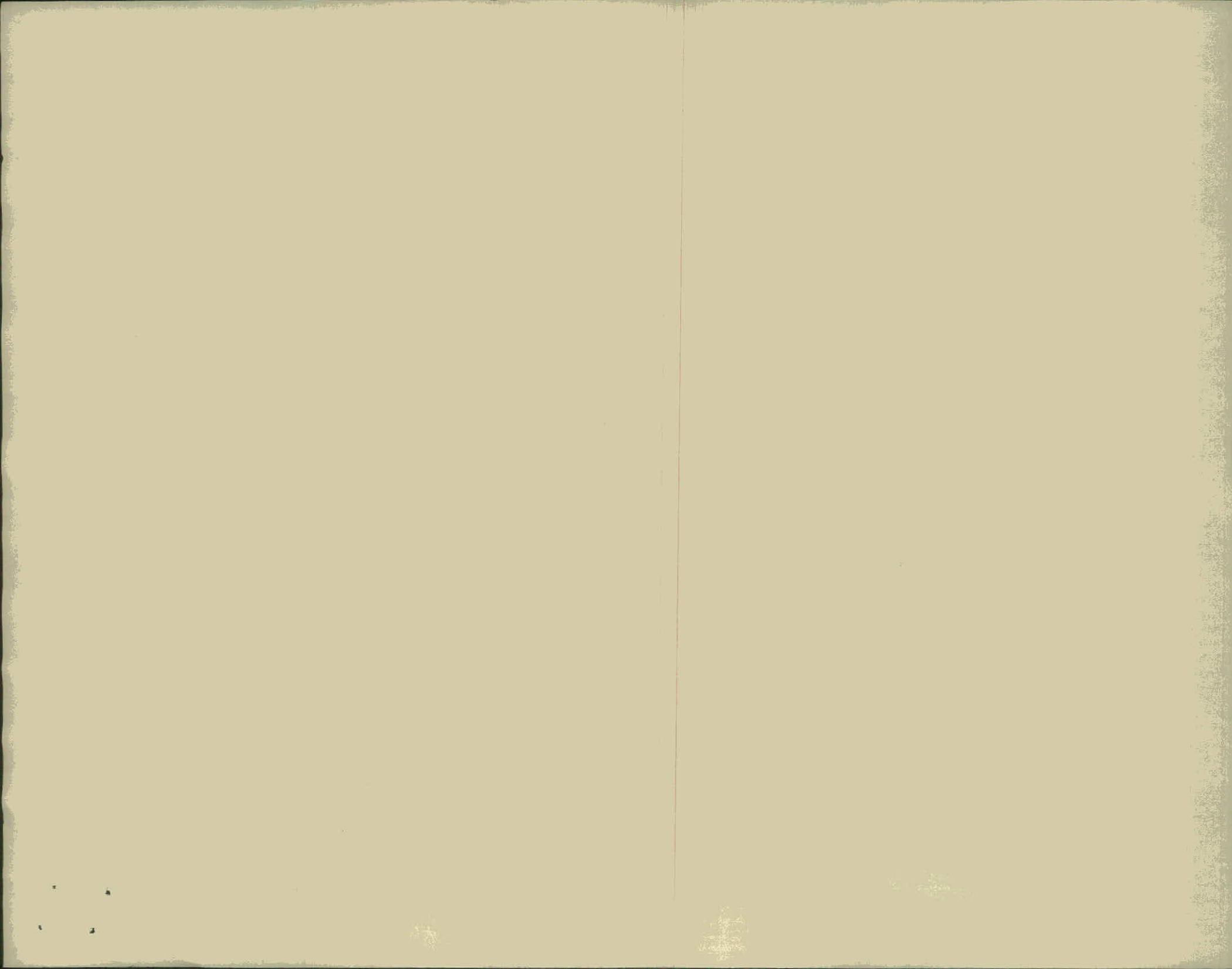
Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3859	B								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.07							
FLOW CNC Waterjet	1-Cut as per Dwg D3859-1 Dwg Rev: <u>15</u> Prog Rev: <u>15</u> 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine VAI/PAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC3- inspect parts - second check								
QC	Memo	0.01							
Quality Control									

MAY 10 2016



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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Weld per dwg A/R S.S. rod Batch: *M123823* 0.00
Large Fab

130

Large Fab

Memo

0.18

1. Weld D4379-5 cups as per dwg D3859
A/R 316L stainless steel rod

*****use DT9462 for welding*****

1. WELD HARDCOAT TO BAR
2659B HARDCOAT BATCH: *M130712*

140

QC9- Inspect visual per QSI004- Fusion Welds 0.00

140

QC

Memo

0.00

Quality Control

150

QC5- Inspect part completeness to step on W/O 0.00

150

QC

Memo

0.01

Quality Control

10

~~16-05-02~~16-05-02
JHL~~16-05-02~~

10 16-06-02

DAS
9
9-89~~16-05-02~~

10 16-06-02

DAS
9
9-89

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Item ID: D3859-041

Accept

N900040100

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20

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

Memo

0.00

~~4 16-06-21~~

10 16-06-21

DAS 34 9-89

~~10 16-06-21~~

10

MAY 30 2016

JUN 02 2016

DAS 38 9-89

10

JUN 02 2016

DAS 36 9-89

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.03

Quality Control

M 5

JUN 03 2016

2m 10/06/02



Picklist Print

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Page 1

Work Order ID: 144312

144312

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate Assembly

Start Date: 4/18/2016

Required Date: 4/29/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4379-5		Manufactured	No			130	Each	100.0000	6	120			
---------	--	--------------	----	--	--	-----	------	----------	---	-----	--	--	--

D4379-5

Wearplate Cup

**

~~06/16/15~~

16-05-01
JBL

Location

Loc Qty

Loc Code

WA001

100

144312

141277

36

141320

64

M304S16GA

Purchased No

100 sf

248.5090

0.85

17

M304S16GA

304/316 Sheet 00.1

**

06/16/14

Location

Loc Qty

Loc Code

MAT019

152.509

m134067

0.706

m134158

37.803

m134399

50

m134551

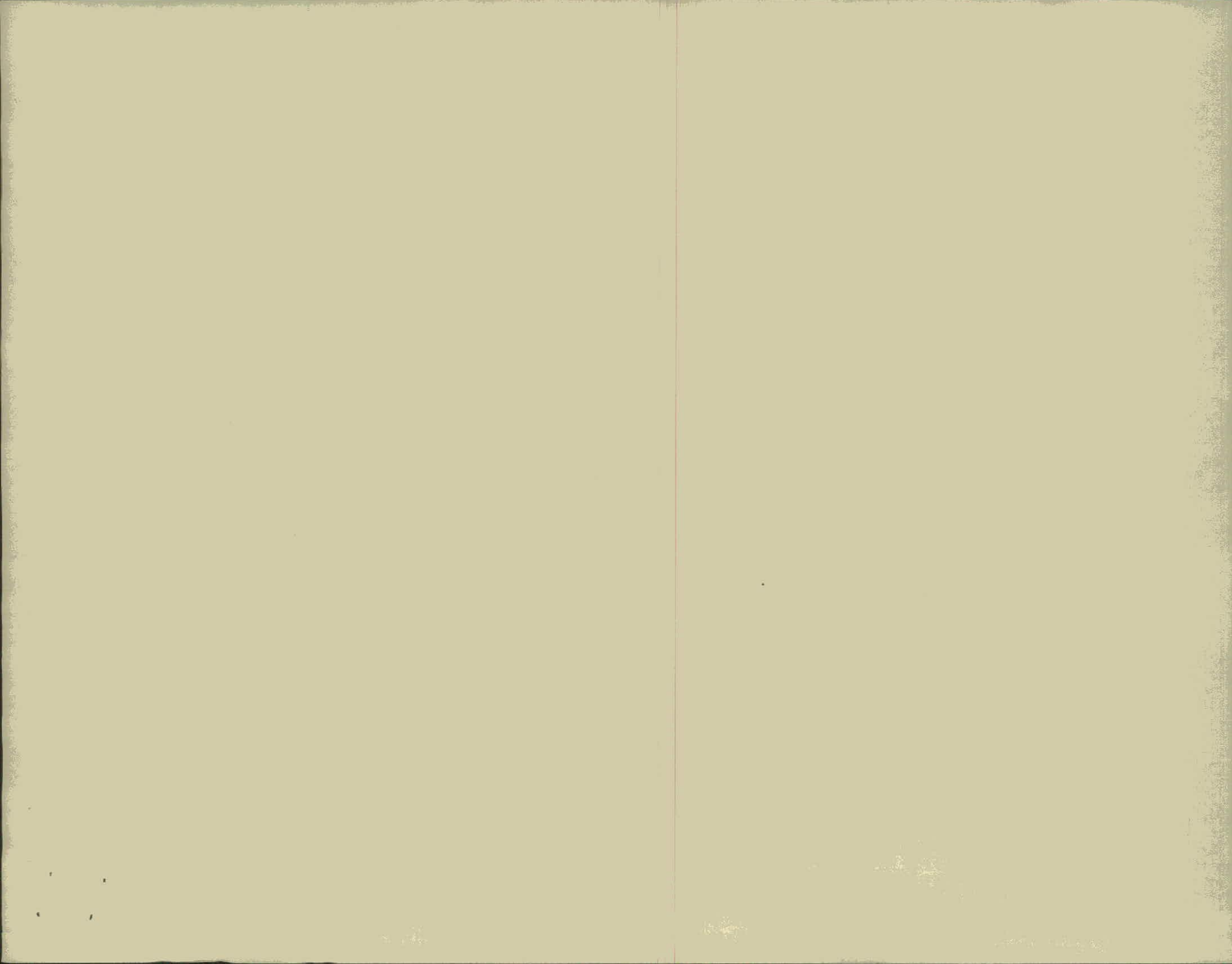
64

TPI

96

m134604

96



ITEM NO.	QTY.	P/N	DESCRIPTION
	X	D3850-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

AS E1E1h1
21709102

20598 HARDCOAT
10 PL

0.06
TO
0.13
HIGH

6
SYM

0.20

1.0
TYP

3.1
TYP

1.50
RFF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL
1/32

6

D3859-041 WEARPLATE

D3659-1 WEARPLATE (1)

INSTALL D4379-5 FLUSH
WITH THIS SURFACE
TYP

D4379-5 WEARPLATE CUP (6)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & D/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 1.58 lbs

8) WELD PER DART QSI 004

RELEASED

2014 MAR 29

PCN # 511

APPROVED

B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	05.01.26
REV	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR	DS		
DATE	14.03.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO
D3859

REV. B

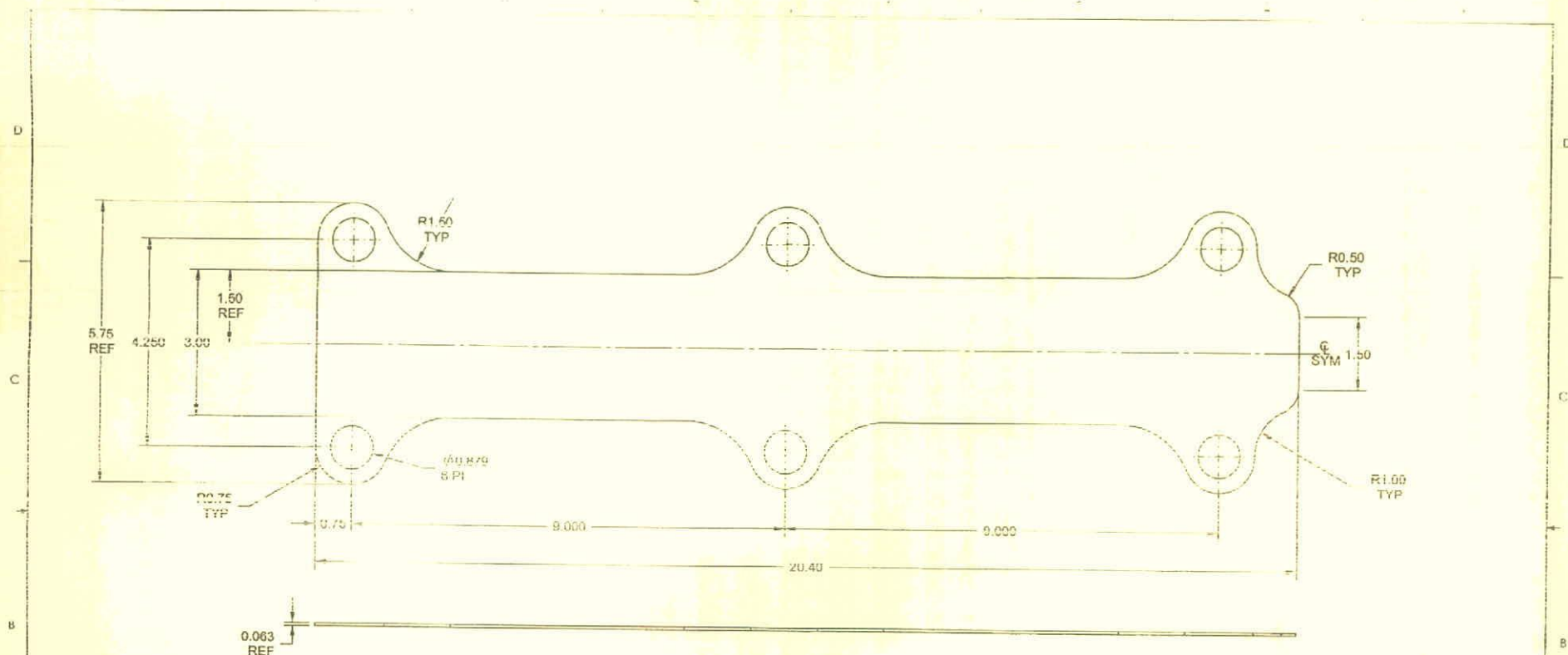
SHEET 1 OF 2

WEARPLATE

NTS

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D3859-1 WEARPLATE

RELEASED

2014 MAR 29 *up*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK).
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D3859	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DB	WEARPLATE	NTS
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